

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK SADDLE	
Job Number	: 36824			
Estimate Number	: 11177			
P.O. Number	:	Part Number	: D2281	
This Issue	: 1/17/2008 S.O. No. :	Drawing Number	: D2281 REV G	
Prsht Rev.	: NC	Project Number	: N/A	
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: G	
Previous Run	: 35471	Material	:	
Written By	: _____	Due Date	: 2/10/2008	Qty: 100 Um: Each
Checked & Approved By	: _____			
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM			
	: Est: rev B 06.07.17 waterjet EC			

Job Number:

1.0 M304S14GA 304SS .080

Comment: Qty.: 0.1313 sf(s)/Unit Total: 13.1250 sf(s)
304SS .080

batch: 105112 HR 8-1-23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: CS

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

Comment: Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 20/02/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 36824

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

80 08/02/14 (76)

7.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

5 08/02/14 (76)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Francis

12/2/14 (76)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(76)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/15

Job Completion



mi 08/02/15 (76)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36824
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.471	X			
4.114	+/-0.010	4.115	X			
2.933	+/-0.010	2.935	X			
1.535	+/-0.010	1.538	X			
0.354	+/-0.010	.354	X			
0.354	+/-0.010	.354	X			
0.604	+/-0.010	.604	X			
2.000	+/-0.010	2.000	X			
3.396	+/-0.010	3.396	X			
3.646	+/-0.010	3.646	X			
4.000	+/-0.010	4.002	X			
1.525	+/-0.010	1.523	X			
2.475	+/-0.010	2.473	X			
Ø0.323	+0.006/-0.001	.325	X			
0.080	+/-0.010	.075	X			

Measured by:	RB	Audited by:	J	Prototype Approval:	N/A
Date:	8-1-23	Date:	08/01/23	Date:	N/A

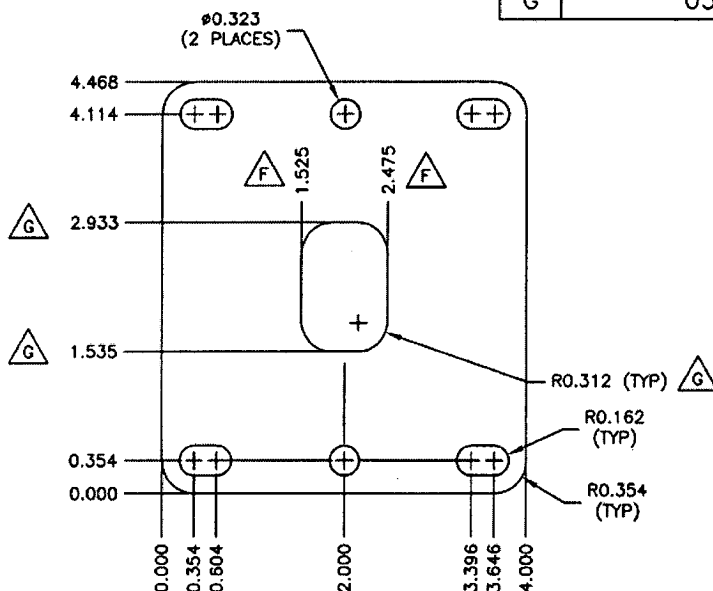
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]



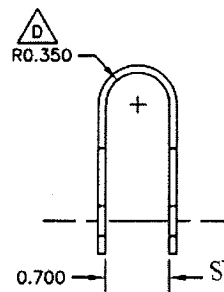
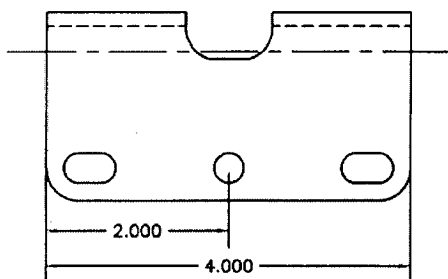
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11



FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36824

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.